

Date: Monday, 02/06/2008 4:39:06 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350/212/130 BASKET LID
<b>Job Number</b> :	39653B		
<b>Estimate Number</b> :	10193		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2512
<b>This Issue</b> :	02/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2512 UNDER REVIEW <i>03.06.03</i>
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39652B	<b>Drawing Revision</b> :	D2
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<i>JUL 08.06.02</i>	<b>Due Date</b> :	15/06/2008
<b>Comment</b> :	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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✓  
**Comment:** Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall *0.065 # 03.06.03*Batch: *M108153*

SAD 08/06/13

⑧

2.0	D31663	Basket Hoop
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✓  
**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3166-3 Basket Hoop *B 38780*

SAD 08/06/16

⑨

3.0	D2506	Label Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2506 Label Plate *D37746*

✓ FC 08 06 23

4.0	D23271	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-1 Bushing *D36920*

✓ FC 08 06 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:39:06 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2232-1 Hinge plate

Batch

35684

✓ FC 08 06 23

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2581 Mounting Bracket

Batch

1739046

✓ FC 08 06 23

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description Batch  
18 sf M304EX0.75-16F Expanded Metal

M107966

SAD 08/06/19 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

FC

2-Cut (4) D2236 From D3166-3

SAD

08/06/16 ①

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

FC

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

FC 08 06 23 ①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-23 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/06/2008 4:39:06 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

808/06/24 (X)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref 4.851) as per QSI 005 4.3

START TIME:

6:35

OVEN TEMPERATURE:

400°

FINISH TIME:

7:05

Coat 2

7:15

400°

7:45

FL 08/06/25

(1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M 107893 FL 08-06-25

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 08/06/26 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

EP 08/06/26 (2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



MF 08-06-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

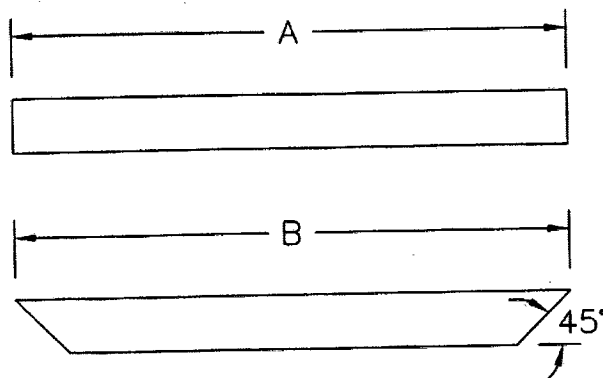


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED  
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



03.06.03  
**UNDER REVIEW**  
08.02.05 #  
TUBING TO BE  
CHANGED TO 0.065  
WALL

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39653B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST 0.065 Pd 03.06.03  
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X (0.060) WALL SQUARE TUBING  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

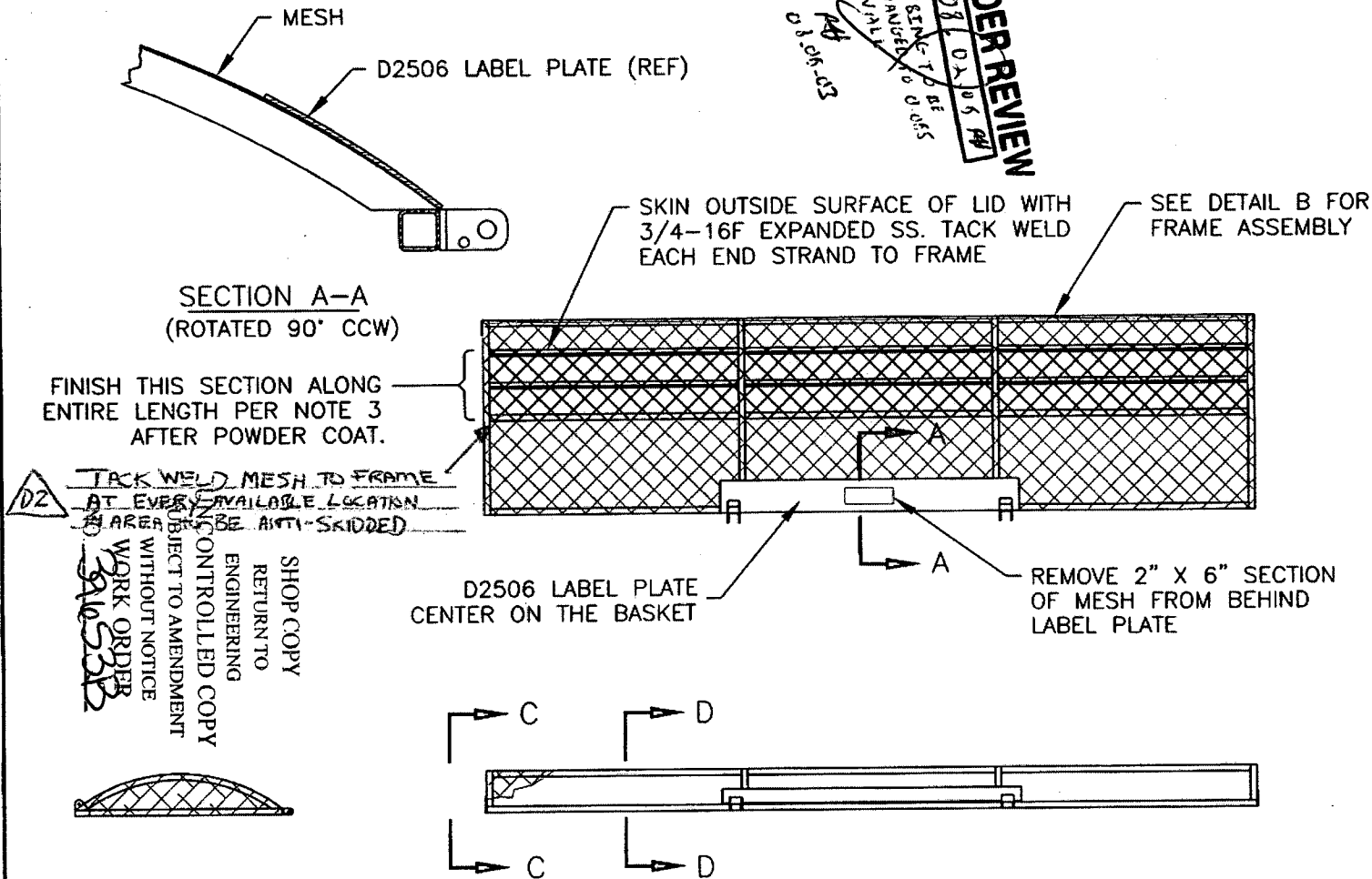
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BW	SC	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE 1:20

UNDER REVIEW  
08.02.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL  
08.03.05



#### D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.04.21

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WORK ORDER  
3410535

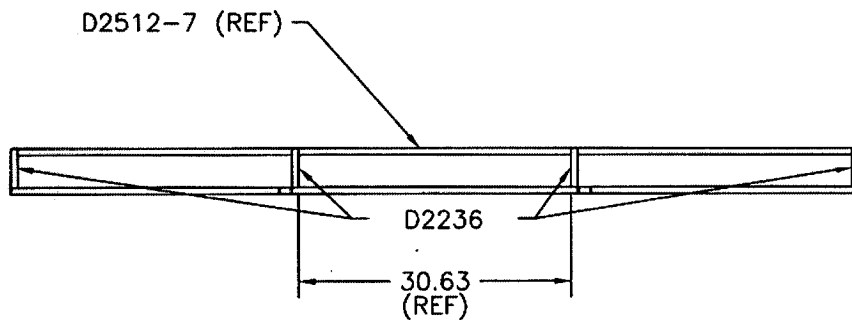
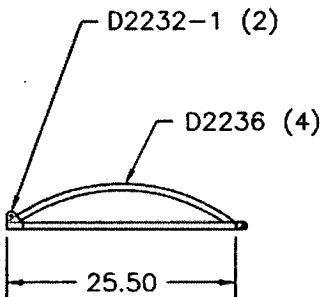




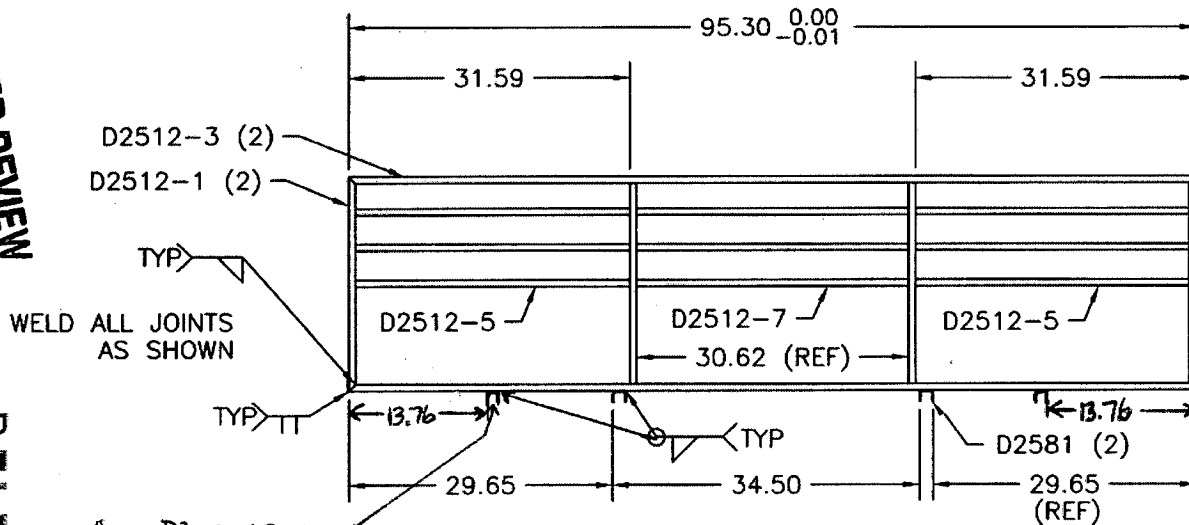




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BW	UP	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2512	SHEET 3 OF 4
DATE	TITLE	SCALE	
01.04.19	BASKET LID ASSEMBLY (350/212)	1:20	



**UNDER REVIEW**  
08.04.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL  
Pdt 08.06.03



D2012-117 CLEVIS  
ADD FOR D130-701-041  
ONLY (2 PLACES)

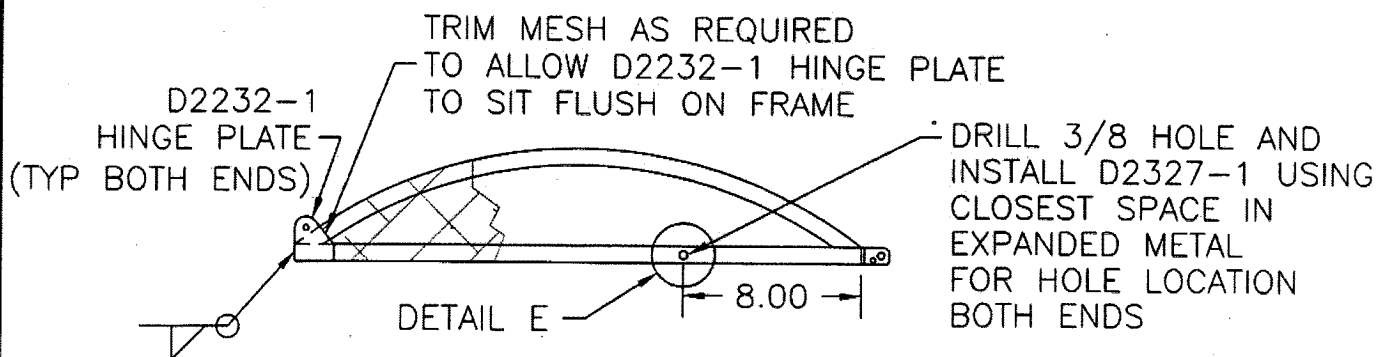
**DETAIL B**  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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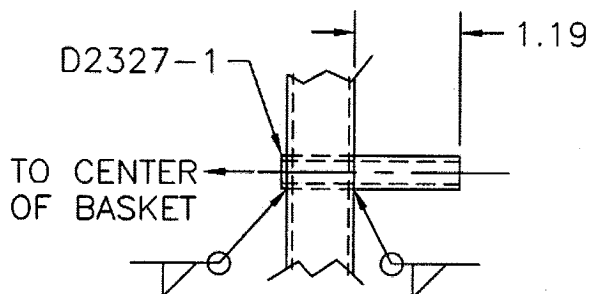
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04.04.27  
WORK ORDER  
3910533B



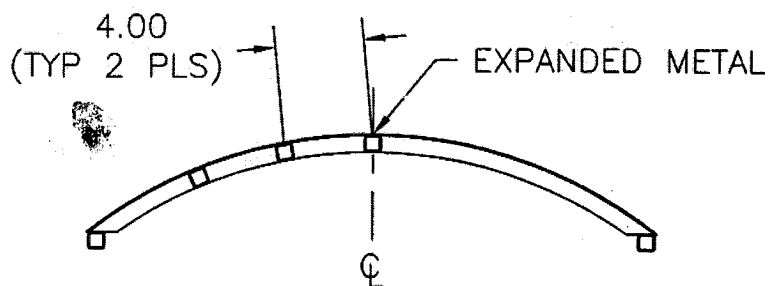
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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

PH 08.06.03  
**UNDER REVIEW**  
08.02.05 PH  
TUBING TO BE  
CHANGED TO 0.065  
WALL

**RELEASED**  
01.04.27

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